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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBW109-3130-82-105
Job Sheet 188803



11730

Part No: RBW109-3130-82-105

Job Qty: 2 pcs

Part Name: Bushing Installation Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3130-82-105 Rev.2 IPP Rev. A 18.12.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	2/8/19		0.00	0.40	Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	2/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
120	Packaging 3-1 - Stock - B4B	2 pcs	2/8/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		



Container No: S159960



Part: RBW109-3130-82-105

Job No: 188803

Serial No/Batch: S159960

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Date: 03/07/19

DAS
40
9-89

MAR 07 2019

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MCC
130 QC 21 - FG	2 pcs	2/8/19	0.00 0.00	QC 21 - FG - 21	21
Part Op					9-88
Descriptions: 100 - Assemble as per DWG.					MAR 08 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
91611A213	Slotted Spring Pin, Ø4.4mm X 30mm	2 Ea (1 ea)	100-Small Fab - 1	5144284
91611A216	Slotted Spring Pin, Ø4.4mm X 36mm	2 Ea (1 ea)	100-Small Fab - 1	5144288
98025A031	Oversized Washer, 3/8 I.D.	2 Ea (1 ea)	100-Small Fab - 1	5144291
FNC-3	Collar Nut	2 (1 ea)	100-Small Fab - 1	5148628
RBW109-3130-82-105-1	Rod Weldment	2 pcs (1 ea)	100-Small Fab - 1	5149820
RBW109-3130-82-105-11	Guide	2 pcs (1 ea)	100-Small Fab - 1	5148473
RBW109-3130-82-105-13	Handle	2 pcs (1 ea)	100-Small Fab - 1	5155973
RBW109-3130-82-105-7	Extension Rod	2 pcs (1 ea)	100-Small Fab - 1	5149346
RBW109-3130-82-105-9	Adapter	2 pcs (1 ea)	100-Small Fab - 1	5156438

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91611A213	2	100	0
	91611A216	2	100	0
	98025A031	2	50	0
	FNC-3	2	0	0
	RBW109-3130-82-105-1	2	0	0
	RBW109-3130-82-105-11	2	0	0
	RBW109-3130-82-105-13	2	0	0
	RBW109-3130-82-105-7	2	0	0
	RBW109-3130-82-105-9	2	0	0

Part Specifications
Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

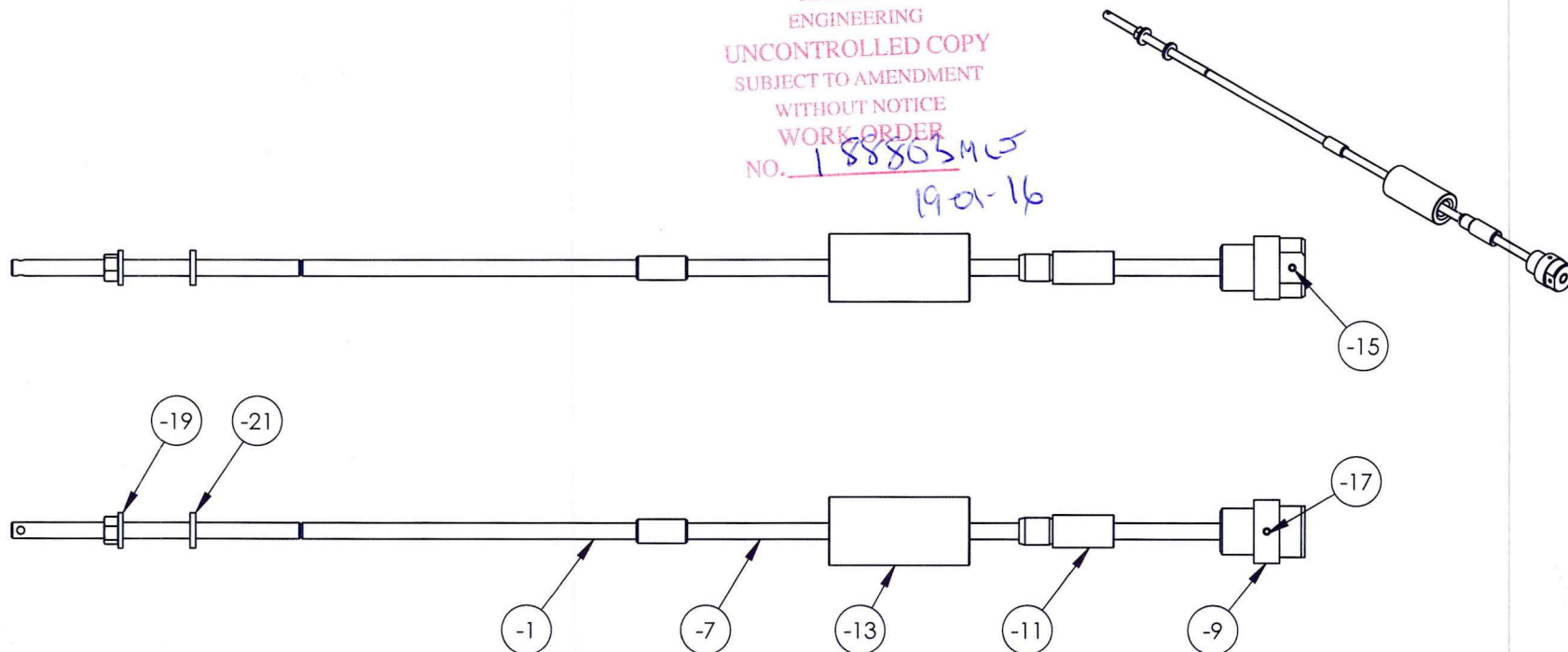
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	14-0230	MADE SEPARATE DRAWING FOR THIS TOOL FROM KIT RBW109-3130-82-139.	1/7/2015	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188805 MJS
1901-16



NOTE:
1. REF. AGUSTA T/N: 109-3130-82-105.
2. PART OF KIT RBW109-3130-82-139.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	ROD WELDMENT			2
	1		-3		THREADED ROD	4140/4142		3
	1		-5		COUPLING NUT	STEEL GRD 5	3/8-16 X 1-3/4 (MCMASTER-CARR #90977A165) MODIFIED	4
			-7	1	EXTENSION ROD	4140/4142		5
			-9	1	ADAPTER	4140/4142		6
			-11	1	GUIDE	4140/4142		7
			-13	1	HANDLE	6061		8
		B/O	-15	1	SLOTTED SPRING PIN	STEEL	Ø4.4mm X 30mm (MCMASTER-CARR #91611A213)	1
		B/O	-17	1	SLOTTED SPRING PIN	STEEL	Ø4.4mm X 36mm (MCMASTER-CARR #91611A216)	1
		B/O	-19	1	COLLAR NUT	STEEL	3/8-16 UNC (REID #FNC-3)	1
		B/O	-21	1	OVERSIZED WASHER	STEEL	3/8 I.D. (MCMASTER-CARR #98025A031)	1
ASSY	-1							

DART AEROSPACE	
TITLE TAIL ROTOR BUSHING INSTALLATION TOOL	
DWG NO. RBW109-3130-82-105	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weid</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 8/26/2010
SHEET 1 OF 8	